

[illegible]

Page 1

Accept

Setup Start

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Process Plan:

Date: 10-6-10

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

Revision Nbr

N/A

Rev N/A

100

0.00

DC

DOCUMENT CONTROL

Document Control

Memo

0.00

Photocopy bluefiles and create labels per PPP D022-714-011 CHG001

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59754

Thursday, June 10, 2010 2:43:11 PM



Page 2

Item ID: D022-714-011

Accept



Setup Start



Revision ID:

Item Name: Replacement Window, (Fits LH & RH)

Stop



Start Date: 6/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D022-714-011								
	Identify and Stock								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

6/10/22 (2)

10/06/23

u code 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




Thursday, June 10, 2010 2:43:16 PM

Page 1



Required Date: 6/18/2010

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8722  template		Manufactured	No			120	Each	0.0000	1	2			
D2126  Seal		Manufactured	No			120	f	388.0034	1	2			
<div> <div> <div>Location</div> <div>ST405</div> <div>48285</div> <div>57106</div> </div> <div> <div>Loc Qty</div> <div>388.0034211</div> <div>22.0884211</div> <div>365.915</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> </div>													
D3317-1  Window		Manufactured	No			120	Each	4.0000	1	2			
<div> <div> <div>Location</div> <div>st200</div> <div>52375</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D022-714-011 Replacement Window Kit (LH/RH)	1.3 lb 0.59 kg	±24.0 in ±0.61 m	±31 in-lb ±0.4 m-kg	79.0 in 2.01 m	103 in-lb 1.2 m-kg
D022-714-014 Bubble Window Kit (RH)	3.0 lb 1.36 kg	+25.0 in +0.63 m	+75 in-lb +0.8 m-kg	79.0 in 2.01 m	237 in-lb 2.7 m-kg

5.0 PARTS LIST

Qty -011	Qty -014	Part Number	Description
X		D022-714-011	REPLACEMENT WINDOW KIT
	X	D022-714-014	BUBBLE WINDOW KIT
1	1	D2126-0830	LOCKING SEAL
1		D3317-1	WINDOW
	1	D3318-2	BUBBLE WINDOW
	1	D3323-1	PLACARD
1	1	*DT8722	WINDOW CUTTING TEMPLATE

* Not to be installed. Cutting template only.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries